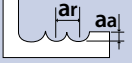




List 78PXB: PXBM Exchangeable Heads

Contouring

| Hardness | | Up to 30 HRC | | 30-45 HRC | | 45-55 HRC | | 55-60 HRC | | | | |
|---|-----------------------|---|--------|-----------------------------|--------|--|--------|-----------------|-------|----------|-------|----------|
| Work Material | | Mild Steels Carbon Steels Cast Iron | | Alloy Steels Tool Steels | | Hardened Steels Pre-hardened Steels | | Hardened Steels | | | | |
| Depth of Cut | Aa=0.02Dc • Ar=0.05Dc | | | | | | | | | | | |
|  | Mill Dia. | | Speed | Feed | Speed | Feed | Speed | Feed | Speed | Feed | Speed | Feed |
| | (in) | (mm) | (RPM) | (in/min) | (RPM) | (in/min) | (RPM) | (in/min) | (RPM) | (in/min) | (RPM) | (in/min) |
| 3/8 | - | 8360 | 197.24 | 8360 | 197.24 | 6695 | 126.40 | 5010 | 78.98 | 3340 | 26.47 | |
| - | 10 | 7960 | 187.80 | 7960 | 187.80 | 6360 | 120.08 | 4770 | 75.20 | 3180 | 25.20 | |
| - | 12 | 6600 | 153.54 | 6600 | 153.54 | 5300 | 98.42 | 3950 | 59.05 | 2600 | 21.65 | |
| 1/2 | - | 6235 | 145.28 | 6235 | 145.28 | 4970 | 92.44 | 3715 | 55.35 | 2230 | 18.51 | |
| 5/8 | - | 4990 | 178.64 | 4990 | 178.64 | 3975 | 114.88 | 2970 | 71.28 | 1925 | 23.87 | |
| - | 16 | 4950 | 177.16 | 4950 | 177.16 | 3950 | 114.17 | 2950 | 70.87 | 1900 | 23.62 | |
| 3/4 | - | 4155 | 145.01 | 4155 | 145.01 | 3310 | 95.00 | 2475 | 62.12 | 1680 | 20.66 | |
| - | 20 | 3950 | 137.79 | 3950 | 137.79 | 3150 | 90.55 | 2350 | 59.05 | 1600 | 19.68 | |
| - | 25 | 3160 | 110.60 | 3160 | 110.60 | 2520 | 71.82 | 1880 | 47.00 | 1280 | 15.75 | |
| 1 | - | 3110 | 108.85 | 3110 | 108.85 | 2485 | 70.82 | 1850 | 46.25 | 1260 | 15.50 | |

- Cutting conditions shown above are for contouring with L/D ≤ 3.5xD.
- Adjust/reduce the cutting conditions when the overhang length is longer than 3.5xD.

